

Work Order ID 130566

130566

Page 1

Monday, March 16, 2015 11:11:03 AM

Item ID: D4941-1L02 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Protector, Fwd LH, (Black)
 Start Date: 3/16/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/16/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-03-16 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4941	D								

100
 100 HAND FINISHING THERMOFORMING 0.00
 Thermoform Memo 0.00
 Thermoforming Machine Cut Blanks

15/03/17

105
 105 Dry Material 0.00
 HandThermo Memo 0.00
 Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE

Temp: 245
 Time IN: 4:36
 Time OUT: 7:00

15/03/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Revision ID:

Stop *NS2*

Item Name: Floor Protector, Fwd LH, (Black)

Start Date: 3/16/2015 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 3/16/2015 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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Work Order ID 130566***130566***

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Item ID: D4941-1L02

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Revision ID:

Stop ***NS2***

Item Name: Floor Protector, Fwd LH, (Black)

Start Date: 3/16/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/16/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9.89
150									
QC	Memo	0.00							
Quality Control									APR 13 2015
160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

INP1016

IX SP15-04-14

MCS 15-04-14

MF
15-4-14

DQA: _____ Date: _____



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Picklist Print

Monday, March 16, 2015 11:11:07 AM

Page 1

Work Order ID: 130566

130566

Parent Item: D4941-1L02

D4941-1L02

Parent Item Name: Floor Protector, Fwd LH, (Black)

Start Date: 3/16/2015

Required Date: 3/16/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL
DL

IPP Rev. B
IPP Rev C revised dwg.
IPP Rev. D Revised dwg. 14/07/25

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F6006-02		Purchased	No			100	sf	2,592.000	4.875	5			
MI FXS 125-F6006-02										**	5	3/15/04/08	
GE PLASTICS LEXAN SHEET(BLACK)													

Location

Loc Qty

Loc Code

MAT020

2592

m128887

2592

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order: 130566
Description:		Part Number: D494/-1L02
Inspection Dwg: D494/ Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 15/04/08

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.0		2.03	✓		DL-02	
.8		.86	✓		DL-02	
.4		.404	✓		DL-02	
6.9		6.95	✓		TH-05	
13.5		13.5	✓		TH-05	
6.9 7.2		7.25	✓		TH-05	
20.1		20.125	✓		TH-05	
20.9		20.875	✓		TH-05	
13.5						

Measured by: JB

Date: 15/04/08

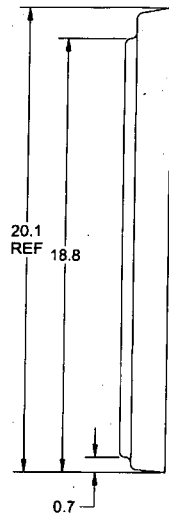
Audited by: 30

Date: APR 13 2015

Preliminary Approval:

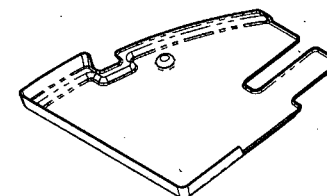
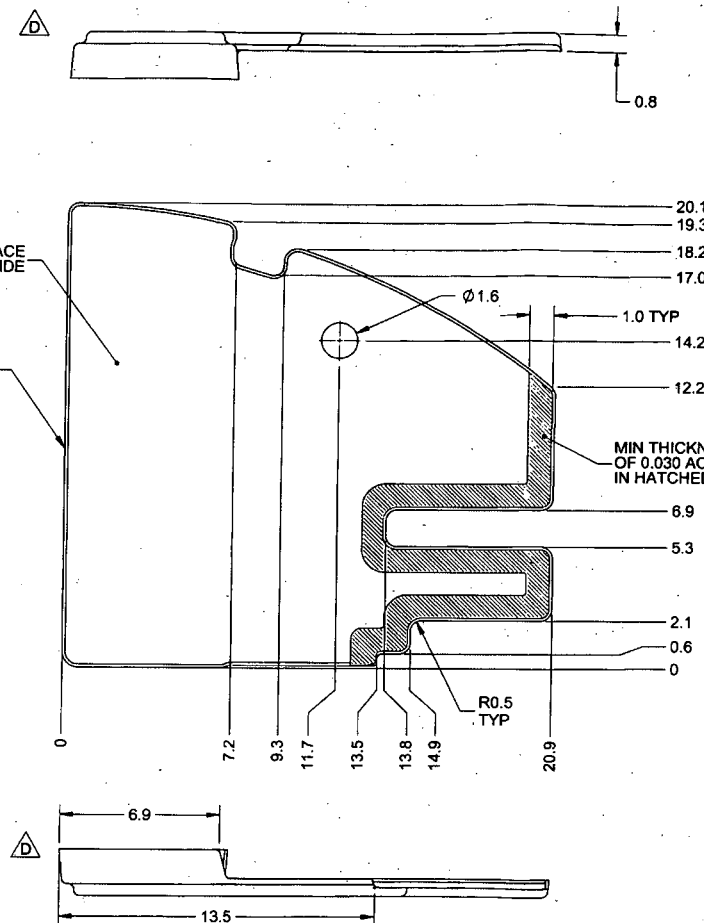
Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	



TEXTURED SURFACE
ON THIS SIDE

6



RELEASED
2014-10-08

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 1.5 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9990
- 9) TRIM PER MOLD LEAVING FINISHED EDGES
- 10) MINIMUM THICKNESS AFTER FORMING IS 0.070"

D4941-1LXX FWD LH FLOOR PROTECTOR

PART NUMBER	DESCRIPTION
D4941-1L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-1L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

D	ADDED VIEWS (ZN C3-1, ZN D6-1, ZN A6-1), EDITED DETAIL D (ZN D2-2) AND DETAIL F (ZN B3-2), EDITED TRIM LOCATION ON D4941-2 (ZN B5-3), EDITED VIEW (ZN D6-3), ADDED VIEW (ZN A6-3), ADDED DETAIL H (ZN C2-3), REVISED D4941-3 AND D4941-4.	AK	14.07.25
C	EDITED TRIM LOCATION ON D4941-1 (ZN D8-2, ZN D6-2, ZN A6-2, ZN D2-2, ZN C1-2), ADDED A CUTOFF TO D4941-2LXX (ZN B5-3), REVISED D4941-4 TO REMOVE CUTOFF (ZN B5-5).	AK	14.06.16
B	REVISED OVERALL DIMENSIONS OF D4941-1/2/3/4	AK	14.02.12
A	NEW ISSUE	AK	13.10.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AK		
DRAWN	AK		
CHECKED	VS		
MFG. APPR.	DL		
APPROVED	HS		
DE APPR.	DS		
DATE	14.07.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4941 REV. D SHEET 1 OF 5

TITLE CABIN FLOOR PROTECTORS SCALE NTS

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